

Date: Thursday, 02/04/2009 3:14:25 PM
 User: Linda Lacelle

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : STRUT |
| Job Number : 46906 | |
| Estimate Number : 10275 | |
| P.O. Number : | Part Number : D2565103 |
| This Issue : 02/04/2009 S.O. No. : | Drawing Number : D2565 REV E |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : E |
| Previous Run : 46837 | Material : |
| Written By : | Due Date : 03/04/2009 Qty: 2 Um: Each |
| Checked & Approved By : | |
| Comment : Est: F02.04.16 Added dwg Rev.C1 NG | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TR0750W049 | 304 RD Tube .750 x .049W |
|-----|----------------|--------------------------|



Comment: Qty.: 1.5934 f(s)/Unit Total: 3.1868 f(s)

304 RD TUBE .750 X.49W

304/316/318-2B Seamless Tubing, 3/4" O.D. x 0.049" wall

(M304TR0750W049)

Batch *M 111096*

SO 09/04/02 (2)

| | | |
|-----|----------|----------|
| 2.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: BRAKE NC

Punch to length as per Dwg D2565 using DT8313

SO 09/04/02 (2)

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill hole open to .316 Ø as per Dwg D2565 (one end only)

2-Deburr

M-1 09/04/02

(2X)

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

SO 09/04/02 (2)

| | | |
|-----|----------------|----------------|
| 5.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



Comment: POWDER COATING

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

M 110939

START TIME: *7:30*

OVEN TEMPERATURE: *700°*

FINISH TIME: *8:00*

BL 09-04-3

(2)

Date: Thursday, 02/04/2009 3:14:25 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 46906

Part Number: D2565103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT

09-04-03

(42)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 270

9/4/3

(2x)

50

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/02 HJ

Job Completion



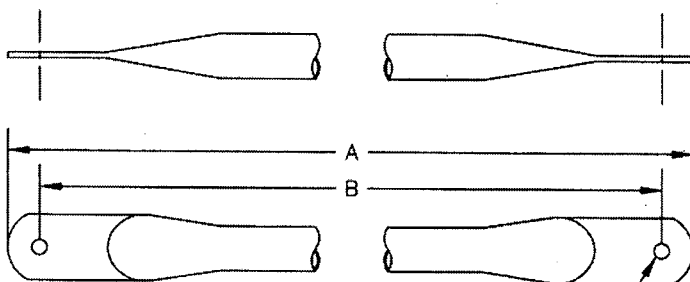
HL 09-04-03



| | | | |
|----------------------------|-----------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2565 | REV. E SHEET 1 OF 1 |
| DATE 04.05.05 | | TITLE STRUT SCALE 1:3 | |
| A | 96.05.03 | NEW ISSUE | |
| B | 97.03.15 | CORRECT D2565-111 DIM. A | |
| C | 98.10.05 | UPDATED MATERIAL NOTE (TSR A603) | |
| D | 02.06.05 | ADD -3XX PARTS; ADD FINISH | |
| E | 04.05.05 | ADD D2565-401-411; RMV ANGLE D | |

RELEASED
04.05.05 *[Signature]*

W/O 46906



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY
PUNCH ENDS PER SPEC CONTROL DRAWING D2638

| PART # | A | B | DIA C |
|-----------|-------|-------|-------|
| D2565-101 | 20.52 | 19.72 | 0.316 |
| D2565-103 | 18.21 | 17.41 | 0.316 |
| D2565-105 | 20.19 | 19.39 | 0.316 |
| D2565-107 | 13.43 | 12.63 | - |
| D2565-109 | 12.31 | 11.51 | - |
| D2565-111 | 13.65 | 12.85 | - |
| D2565-201 | 22.79 | 22.00 | 0.316 |
| D2565-203 | 20.75 | 19.95 | 0.316 |
| D2565-205 | 21.22 | 20.42 | 0.316 |
| D2565-207 | 16.07 | 15.27 | - |
| D2565-209 | 15.16 | 14.36 | - |
| D2565-211 | 14.14 | 13.34 | - |
| D2565-301 | 27.03 | 26.23 | 0.316 |
| D2565-303 | 25.34 | 24.54 | 0.316 |
| D2565-305 | 23.73 | 22.93 | 0.316 |
| D2565-307 | 20.86 | 20.06 | - |
| D2565-309 | 20.17 | 19.37 | - |
| D2565-311 | 16.30 | 15.50 | - |
| D2565-401 | 18.29 | 17.49 | 0.316 |
| D2565-403 | 15.64 | 14.84 | 0.316 |
| D2565-405 | 19.45 | 18.65 | 0.316 |
| D2565-407 | 10.79 | 9.99 | - |
| D2565-409 | 9.34 | 8.54 | - |
| D2565-411 | 13.81 | 13.01 | - |

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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